

**Work Order ID 55089**

Page 1

January 5, 2010 3:16:13 PM

Item ID: D3823-1KGY

Accept



Setup Start



Revision ID:

Item Name: Overhead Rear, LH-Grey

Stop



Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-1-05 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
100	

100	0.00	
Hand Thermo	Memo	0.00

Hand Finishing Thermoforming      1-Cut Sheet to required Blank size

  
10/01/27

110	0.00	
Thermoform	Memo	0.00

Thermoforming Machine      1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA030 using tool DT9112  
Dwg Rev: S      Folio Rev: S

  
10/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 55089**

Page 2

January 5, 2010 3:16:13 PM

Item ID: D3823-1KGY

Accept



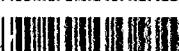
Setup Start



Revision ID:

Item Name: Overhead Rear, LH-Grey

Stop



Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



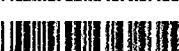
QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
**Set Up/  
Run Hours**
**Draw  
Number**
**Draw  
Rev.**
**Plan  
Code**
**Accept  
Qty**
**Reject  
Qty**
**Reject  
Number**
**Insp.  
Stamp**

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

B  
10/01/27  
X1

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DH 10/01/27  
X1

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

DH 10/01/28  
X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 55089**

Page 3

January 5, 2010 3:16:14 PM

Item ID: D3823-1KGY

Accept



Setup Start



Revision ID:

Item Name: Overhead Rear, LH-Grey

Stop



Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
**Set Up/  
Run Hours**
**Draw  
Number**
**Draw  
Rev.**
**Plan  
Code**
**Accept  
Qty**
**Reject  
Qty**
**Reject  
Number**
**Insp.  
Stamp**

150



QC2- Inspect parts off machine FAI/FAIB

0.00

Dh 10/01/28

QC

Quality Control

Memo

0.00

Complete FAI document

(X)

160



QC5- Inspect part completeness to step on W/O

0.00

⇒ S. 10/01/28

(X)

QC

Quality Control

Memo

0.00

170



Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

10-1-28 RSP

Packaging

Packaging

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 55089**

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January 5, 2010 3:16:14 PM

Item ID: D3823-1KGY

Accept



Setup Start



Revision ID:

Item Name: Overhead Rear, LH-Grey

Stop



Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Customer:

Required Date: 15/01/2010 Req'd Qty: 1.00



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

180

QC21- Final Inspection - Work Order Release



QC

Memo

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

Quality Control

10/01/29 JF

MF

10-1-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

January 5, 2010 3:16:18 PM

Page 1

Work Order ID: 55089



Parent Item: D3823-1KGY



Parent Item Name: Overhead Rear, LH-Grey

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Buy/ Search	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	519.7508	11.1556			

Kydex steel grey

	<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	<u>Location</u>		
	Main Warehouse		
	MAT	519.7508	
	111807	519.7508	

BB  
10/01/27  
XV

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	55689
Description: Rear Overhead, LH	Part Number:	D3823-1KIV/KGY
Inspection Dwg: D3823	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

## **THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by

Oh...

Date:

10/01/27

## **TRIMMING SECTION**

#### **Measured by**

W.H.

Date:

9/01/28

**Audited by:**

1

Date:

5/6/25

#### **Prototype Approval:**

N/A

Date:

N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

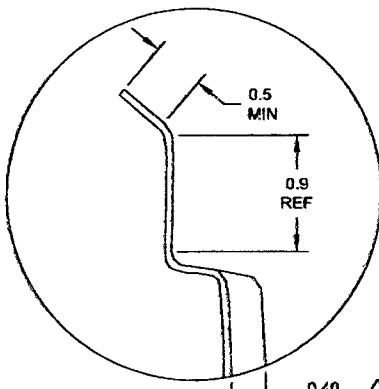
WORK ORDER

NO. 55089

*B10-1-05*

MIN THICKNESS  
0.045  
(SHADED REGION)

B8-1  
**DETAIL B**



**DETAIL B**  
SCALE 5X

C4-1  
**SECTION A-A**

**D3823-1 REAR OVERHEAD, LH**

PART NUMBER	DESCRIPTION
D3823-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)



5

4

3

2

1

6

5

4

3

2

1

B8-1  
**A**

**B**

0.44  
MIN

35.94  
REF

TEXTURED SIDE

A

1.75  
MIN

14.3  
REF

**RELEASED**  
*B10-1-05*

C	ADD STEEL GRAY COLOUR OPTION. ADD IVORY PINS D3823-1/2-3(KIV) AND ADD STEEL GRAY PINS D3823-1/2-3(KGY) (IN A5-1, A5-2, A5-3)	PH	09.05.05
B	ADD JOGGLE TO D3823-1/2-6 FOR BETTER FIT WITH D3824-1/3 HAT BIN (IN C5-1, C5-2, C8-3); 0.40 WAS 0.18 (IN B7-1, D7-2); 0.45 WAS 0.29 (IN B8-3)	PH	09.06.06
A	NEW ISSUE	PH	08.09.28
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AB</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>AB</i>	HALIFAX, NS, CANADA	
CHECRED	<i>AB</i>	REV. C	
MFG. APPR.	<i>AB</i>	D3823	SHEET 1 OF 3
APPROVED	<i>AB</i>	TITLE	SCALE
DE APPR.	<i>AB</i>	REAR OVERHEAD	INTS
DATE	09.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD THE INFORMATION CONTAINED HEREIN IS UNPUBLISHED PROPERTY OF THE COMPANY THAT IT IS NOT TO BE COPIED IN ANY FORM OR PART, IN WHOLE OR IN PART, OR DISCLOSED OUTSIDE DART AEROSPACE LTD, WITHOUT PRIOR WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9112 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

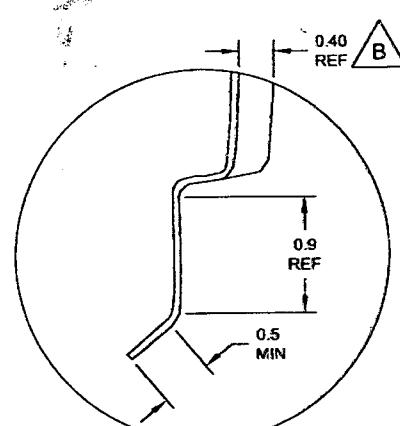
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC, Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

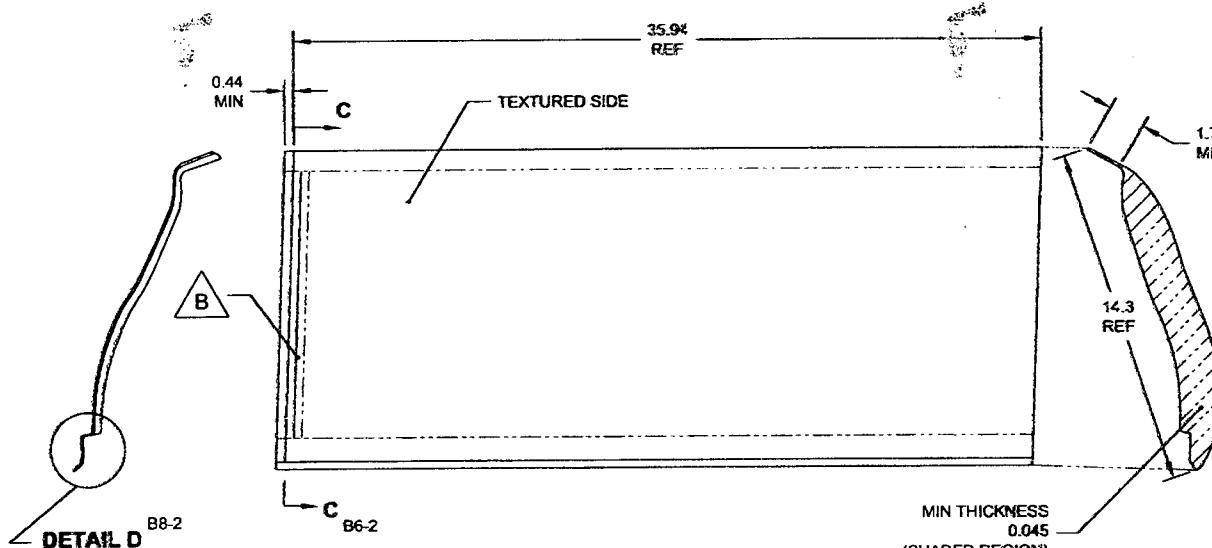
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1 D



**DETAIL D**  
SCALE 5X

**SECTION C-C**

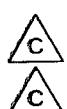


**D3823-2 REAR OVERHEAD, RH**

**RELEASED**  
*05/21/17*

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9113 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION	DESIGN DRAWN CHECKED MFG. APPR. APPROVED DE APPR.	REV. C DRAFT DRAWING NO. D3823 SHEET 2 OF 3 TITLE REAR OVERHEAD
D3823-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)		
D3823-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)		

8 7 6 5 4 3 2 1 C

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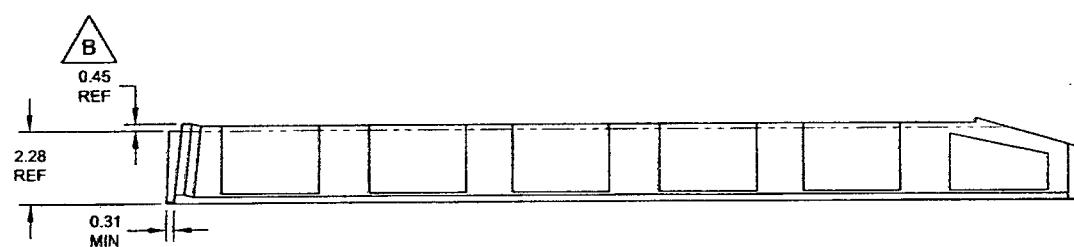
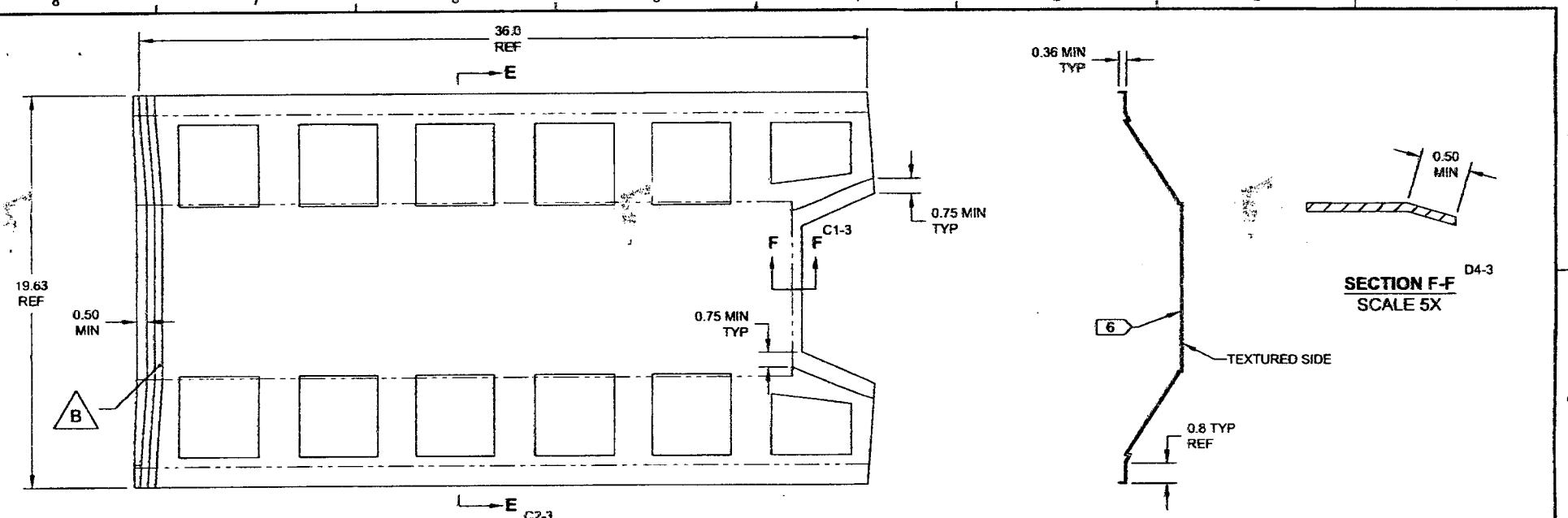
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC, Inspector,

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

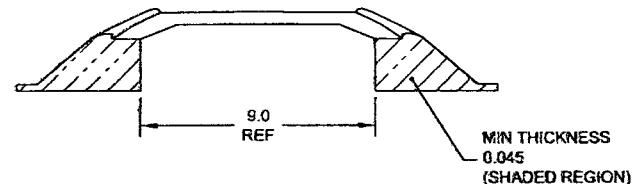
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3823-3 REAR OVERHEAD, CENTER



RELEASED  
6/5/2014

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 2.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9110 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

C  
C

PART NUMBER	DESCRIPTION
D3823-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	RE	DART AEROSPACE LTD
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.	D/P	D3823
APPROVED	MV	REV. C
DE APPR.	MM	SHEET 3 OF 3
DATE		TITLE
09.05.05		SCALE
		NTS
REAR OVERHEAD		
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